

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014055**Date Inspected:** 13-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Orthotropic Box Girder(OBG)				

Summary of Items Observed:

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

LAY DOWN YARD.

The following Non Destructive Testing (NDT) Inspection carried out as per the ZPMC submitted Notification No. 005723.

Magnetic Particle Testing (MT)

This QA Inspector performed MT of 100% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG

Segment:10BE-Panel Point(PP)#89(West side) weld Components. Total number of welds MT Tested: 102 No's.

The weld designations are review as follows:

1. DP506-001-007,008,010,013,014,016,018,019,022,023,025,027,028,031,032,034.
2. DP344-001-009,010,012,015,016,018,020,021,024,025,027,029,030,033,034,036,038,039,042,043,045.
3. DP479-001-011,012,014,017,018,020,022,023,026,027,029,031,032,035,036,038,040,041,044,045,047,049,050,053,054,056.

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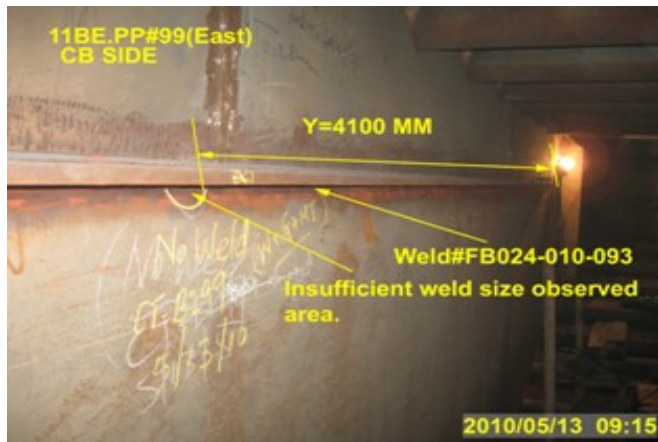
4. DP452-001-011,012,014,017,018,020,022,023,026,027,029,031,032,035,036,038,040,041,044,045,047,049,050,053,054,056.
5. DP425-001-011,012,014,017,018,020,022,023,026,027,029,031,032.

This QA Inspector performed MT of 100% of the area previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA generated MT report for this date. The members are identified as OBG Segment:11BE-PP #98 & 99(East side) weld Components. Total number of welds MT Tested: 04 No's. The weld designations are review as follows:

1. FB003-197-004
2. FB024-010-093
3. FB020-008-093
4. FB003-184-004.

During MT/Visual Testing this QA Inspector observed that the weld size (Excess ground area) was not sufficient at one location. The length is approximately 50 mm. The weld is identified as FB024-010-093. This QA informed to ZPMC QC identified as Mr. Tang Ya Jun of this issue. As per ZPMC QC the area will be repaired by welding and perform MT. Refer attached photos for reference.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and Quality Control (QC) concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhu,Surendra	Quality Assurance Inspector
Reviewed By:	Hall,Steven	QA Reviewer
